

**Work Order ID 68739**

Page 1

Thursday, April 21, 2011 8:15:46 AM

Item ID: D350-636-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 4-21-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3492

C

D4168

A

IIN-D350-636

H

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-015 CHG 002

u/a

B70253

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

**Memo**

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside  
AFT end per dwg D41683- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",  
deburr, section H-H4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade  
fitting, section H-H5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per  
dwg D4168, detail A6- Drill pilot holes as per Dwg D4168 sheet 4 (D4168-1 details). Drill using drill  
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole.

9-Open up holes of Detail A to 0.297" (total of 2 holes per side) and .201" (total  
of 1 hole per side) open holes of detail D section H-H to 0.500" as per dwg  
D416810-Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004

BB

11/04/26

BE 11/04/26

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
StampA/R Aluminum Rod batch: ☐ MIL6577

BE 11/04/26

11-Grind welds flush as per Dwg D4168

BB

11/04/26

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/4/26

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/4/26

70

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

EMK 11/05/02



150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

1 p 11/05/02

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Sequence ID/  
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DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail C and ground handling section AL-AL to 0.625"  
(total of 8 holes per side)  
as per dwg D4168.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D4168.

3- Open float hole to 0.500" (4 per side) section AJ-AJ

Open wearplate holes to size as per dwg (4 holes per sides) , section CG-CG

4-Chamfer holes of Detail B, C, ground handling section AL-AL and float holes  
section AJ-AJ per dwg D4168 (welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI015

A/R ☐☐☐ Sikaflex-291 batch: 116918 ☐☐☐  
exp. date: 12/1/15

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1  
& QSI004

(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod batch: M116577

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

*11/05/05*

*11/05/05*

*11/05/05*

*BE 11/05/12*

*BE 11/05/12*

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Customer:

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

10-Grind welds flush as per Dwg D4168

11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D4168, section AL-AL

12- C'bore section CG-CG

13- Deburr holes

BB 11/05/11  
BE 11/05/12

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8 11/05/13

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 11/05/13

HL

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing



Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 ~~0~~ M 11/06/06

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:30

OVEN TEMPERATURE: 220

FINISH TIME: 2:00

1x ~~0~~ M 11/06/06

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



Inspect for foreign object per QSI 024

1 ~~0~~ M 11/06/09

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
	HandFinishing					1	0	21	u106109
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D4168								
230		0.00							
	HandFinishing					1	0	21	u106109
HandFinish	Memo	0.00							
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>D112</u>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168 SIKA FLEX 241 BATCH: <u>M116945</u> EXP DATE: <u>12/01</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M114184</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>M114396</u>								

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

nd 11 16 13 ①

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

If making a D350-636-215  
pick kit will only requires:  
1 X AN3C37A  
1 X AN3C34A  
1 X AN3C42A  
2 X D3493-1

11/6/13

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

Sulog 1/4

④

W/O:		WORK ORDER CHANGES					
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
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Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD350-636-015

Location:

PPP rev: PPA 70203

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

Pu/6/10211/6/15MWF 11-06-15

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# Picklist Print

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Page 1

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Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 4/20/2011

Required Date: 4/25/2011


Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC  
11.04.14 ecn11-553 DD verf:EC


IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C34A		Purchased	No			230	Each	13.0000	1	1			
													
BOLT													

Location Loc Qty Loc Code

ST353 13  
116003 13

AN3C36A		Purchased	No			230	Each	181.0000	4	4			
													
BOLT													

Location Loc Qty Loc Code

FG 14  
101261 4  
116590 10  
FP-B 47  
111925 47  
ST303 20  
116590 20  
ST353 100  
117125 100

1

4

116003

x4

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Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C37A

Purchased No

230

Each

129.0000

1

1



BOLT

Location

Loc Qty

Loc Code

ST353

29

116874

11

117010

18

ST354

100

117343

100

AN3C42A

Purchased No

230

Each

52.0000

1

1



BOLT

Location

Loc Qty

Loc Code

ST354

52

106176

52

D3492-1

Manufactured No

230

Each

0.0000

8

8



Plug

D3492-3

Manufactured No

230

Each

0.0000

8

8



Plug

D3873-1

Manufactured No

230

Each

123.0000

7

7



Bushing

Location

Loc Qty

Loc Code

ST088

123

62197

12

63314

2

64567

9

64760

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, April 21, 2011 8:15:54 AM

Page 3

Work Order ID: 68739

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D4154-041 Manufactured No

230 Each

0.0000

1 1



368361 (x1) ul u106109

Wearplate Assembly

D4170-1 Manufactured No

230 Each

50.0000

4 4



881/05/06

Bushing

## Location

## Loc Qty

## Loc Code

LG

46

61581

5

68225

41

LG002

4

65912

4

D4171-1 Manufactured No

230 Each

8.0000

1 1



ul u106109

Bushing

## Location

## Loc Qty

## Loc Code

ST135

8

65646

8

MS21043-3 Purchased No

230 Each

930.0000

5 5



ul u106109

Nut

## Location

## Loc Qty

## Loc Code

FG

80

103691

80

FP-B

-5

112314

-5

ST301

855

112314

855

x4

Thursday, April 21, 2011 8:15:54 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 8:15:54 AM

Work Order ID: 68739



Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0363R

Purchased

No

230

Each

4,735.000

9



Washer



97  
JL

1106109

Location

Loc Qty

Loc Code

ST297

4735

113889

81

114742

4654

NAS1515H3L

Purchased

No

230

Each

285.0000

4



WASHER



47  
4

1106109

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

245

113362

245

NAS1611-010

Purchased

No

230

Each

266.0000

8



O-RING



44  
8

1106109

Location

Loc Qty

Loc Code

FP

80

117460

80

FP-A

186

110915

139

115589

47

88

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 8:15:54 AM

Work Order ID: 68739



Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

176.0000

8

8



O-RING



all 4/20/11

Location

Loc Qty

Loc Code

FP

171

117291

131

117460

40

FP-A

5

116582

5

x 8

AN960JD816

Purchased

No

250

Each

45.0000

2

2



1/2" washer, Alum



all 4/20/11

Location

Loc Qty

Loc Code

FP-A

45

106043

45

x 2

D2744

Manufactured

No

110

Each

37.0000

1

1



Cap



BE 4/20/11

Location

Loc Qty

Loc Code

LG002

37

62715

8

65086

29

/

D2600-3-BENT

Manufactured

No

110

Each

29.0000

1

1



Extrusion Bent



Location

Loc Qty

Loc Code

LG

29

66874

1

66875

8

68137

10

68138

10

1

Thursday, April 21, 2011 8:15:55 AM

Shop Packet Print

BE 4/20/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 6

Thursday, April 21, 2011 8:15:55 AM

Work Order ID: 68739



Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

123.0000

8

8



Crossbolt Spacer



BE 11/05/06

Location

Loc Qty

Loc Code

LG001

123

67766

123

B

D2739

Manufactured No

160

Each

14.0000

1

1



350 I Beam



Location

Loc Qty

Loc Code

LG

14

67785

2

68285

6

68286

6

4

D3490-3

Manufactured No

160

Each

66.0000

4

4



Cross Bolt Spacer



B 11/05/05  
BE 11/05/06

Location

Loc Qty

Loc Code

LG

26

68106

26

LG001

40

67774

40

4

D3490-1

Manufactured No

160

Each

93.0000

4

4



Cross Bolt Spacer



BE 11/05/06

Location

Loc Qty

Loc Code

LG

91

67773

31

68105

60

LG001

2

62450

2

4

Thursday, April 21, 2011 8:15:55 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 7

Thursday, April 21, 2011 8:15:55 AM

Work Order ID: 68739



Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

1,113.000

4

4



Insert



Handwritten: 1106109

## Location

## Loc Qty

## Loc Code

FP-B

40

110768

40

Handwritten: 84

ST282

1073

110768

1073

AN8C35A

Purchased

No

230

Each

30.0000

1

1



BOLT



Handwritten: 1106109

## Location

## Loc Qty

## Loc Code

FP-A

30

115960

7

Handwritten: 81

116874

23

D3488-041

Manufactured

No

230

Each

4.0000

1

1



Handwritten: 1106109

## Location

## Loc Qty

## Loc Code

FP007

1

Handwritten: 1368108

61689

1

Handwritten: 81

FP008

3

62002

3

Thursday, April 21, 2011 8:15:55 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 8

Thursday, April 21, 2011 8:15:55 AM

Work Order ID: 68739



Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

86.0000

4

4



BOLT



*all u106109*

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

84

116874

4

117407

80

*x4*

MS21083C8

Purchased

No

230

Each

91.0000

1

1



NUT



*all u106109*

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST303

90

115884

0

117291

40

*x1*

117423

50

D3631-1

Manufactured

No

230

Each

500.0000

8

8



Washer



*all u106109*

Location

Loc Qty

Loc Code

ST072

500

68062

500

*B63617*

*x8*

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

4

4



washer



*1117291 (x8) all u106109*

Thursday, April 21, 2011 8:15:56 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 8:15:56 AM

Work Order ID: 68739

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No

230 Each

13.0000

8 8



Bushing



1368248 (x8) JEL u106109

Location

Loc Qty

Loc Code

FP-A

13

67764

13

AN960C816L

Purchased No

230 Each

0.0000

1 1



NAS1149C0832R1 M114915



(x1) JEL u106109

WASHER

AN3C6A

Purchased No

230 Each

224.0000

4 4



JEL u106109

BOLT

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

223

111982

2

116419

71

116549

50

116704

100

x4

MS21043-6

Purchased No

230 Each

527.0000

4 4



JEL u106109

NUT

Location

Loc Qty

Loc Code

FG

20

103693

20

FP-A

44

112314

44

ST301

463

112314

463

x4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 8:15:56 AM

Work Order ID: 68739



Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250 Each

33.0000

2

2



Washer



11/6/11 SP

## Location

## Loc Qty

## Loc Code

ST062

33

66975

33

2

MS21083C8

Purchased

No

250 Each

91.0000

2

2



NUT



ul ulowlog

## Location

## Loc Qty

## Loc Code

FP-B

1

115884

1

ST303

90

115884

0

117291

40

117423

50

x2

AN8C21A

Purchased

No

250 Each

28.0000

2

2



BOLT



ul ulowlog

## Location

## Loc Qty

## Loc Code

ST345

28

116381

28

x2

D2741

Manufactured

No

250 Each

50.0000

1

1



Blade, 350 Skidtube



SP

## Location

## Loc Qty

## Loc Code

ST466

50

61341

12

63589

38

/

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

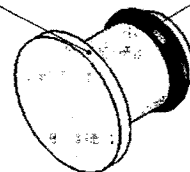
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3492-XX PLUG  
(SEE TABLE)

NAS1611 PLUG  
(SEE TABLE)



# D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
	1					1	NAS1611-012	O-RING
							NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ △ △

## NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 08739

11-04-21

~~UNDER REVIEW~~

06.04.21 08  
OK 155 08.11.12

DEO ATTACHED

RELEASED  
07.10.05

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047, UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3492** REV. C  
SHEET 1 OF 2  
TITLE **PLUG** SCALE 2:1

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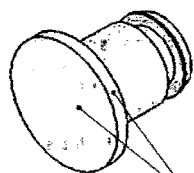
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

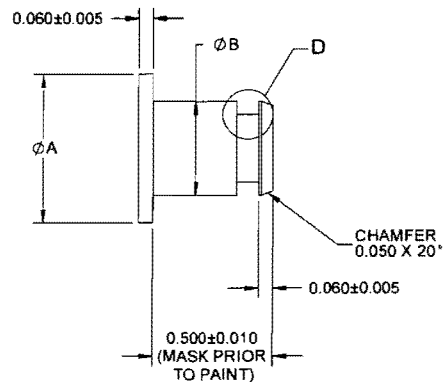
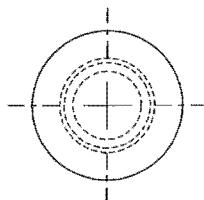
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

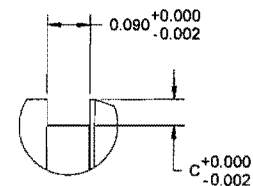
**NOTE:** Date & initial all entries



POWDER COAT THESE  
FACES ONLY PER NOTE 2



**D3492-XX PLUG**



**DETAIL D**

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

u/068739

UNDER REVIEW

01.04.11 RGA  
DIN 10 ON D3492-13  
REV. 12 (WHITE SHIMMER)  
ASS 08.11.12  
OKay

DEO ATTACHED

RELEASED  
07.11.16

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3492	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	4:1
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08/11/05	DATE 08/11/05			

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

w/o 68739

WAS:

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

**RELEASED**  
08/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

u/068739

# GENERAL NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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2010-09-15

A		NEW ISSUE		SC	10.08.09
REV.		DESCRIPTION	BY	DATE	
DESIGN	SC	DART AEROSPACE USA, INC.			
DRAWN	SC	PORT HADLOCK, WA			
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D4168	SHEET 1 OF 11		
APPROVED		TITLE	SCALE		
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS		
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

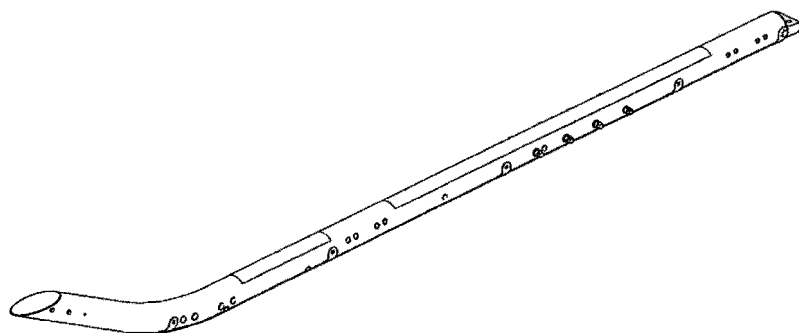
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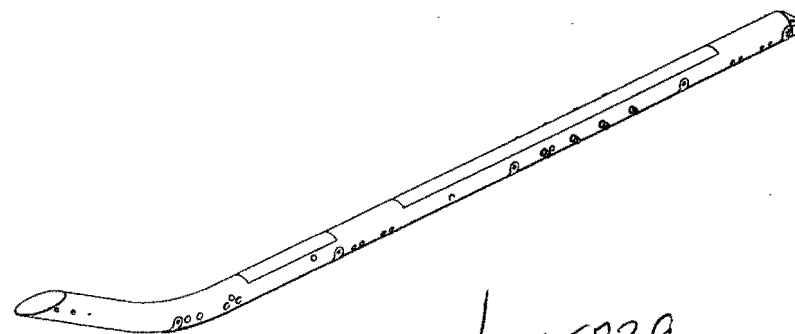
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D4168-041 350 SKIDTUBE ASSEMBLY, LH**



**D4168-042 350 SKIDTUBE ASSEMBLY, RH**

61068739

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2010-09-15  
JW

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MFG. APPR.	<i>[Signature]</i>	D4168	SHEET 2 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

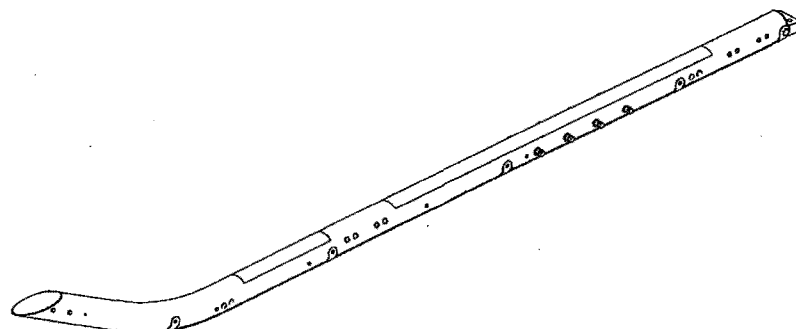
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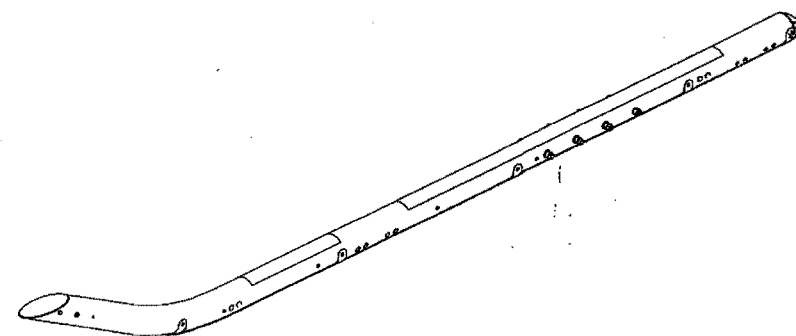
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

u/068739



**D4168-043 350 SKIDTUBE ASSEMBLY, LH**



**D4168-044 350 SKIDTUBE ASSEMBLY, RH**

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2010-09-15

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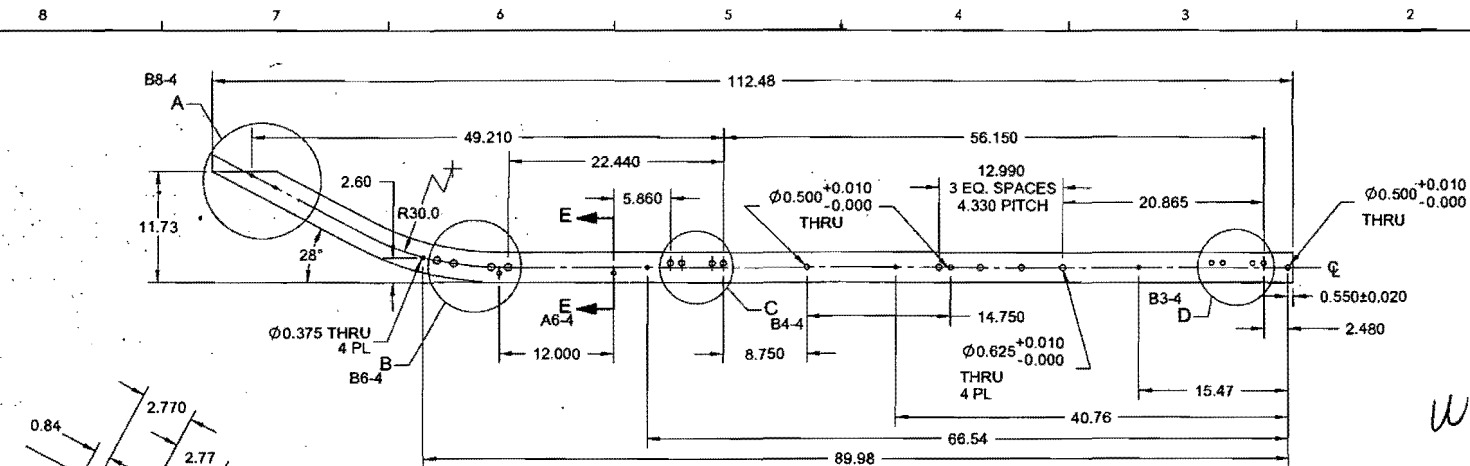
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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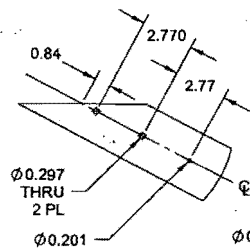
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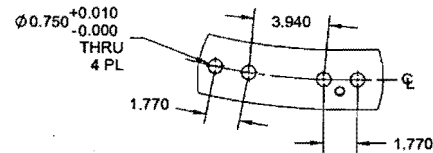


w/b 68739

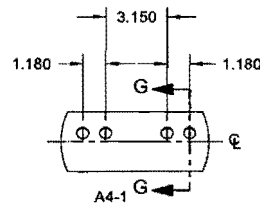
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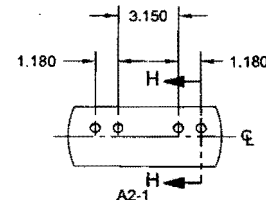
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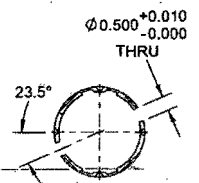
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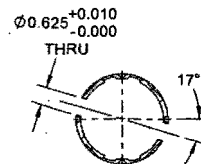
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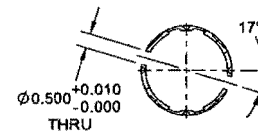
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SCALE 2X



**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

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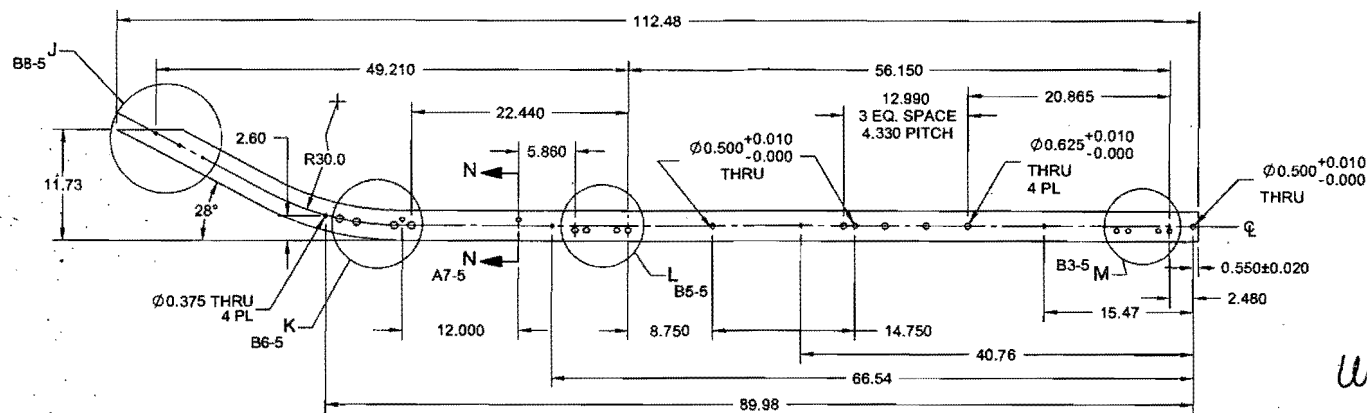
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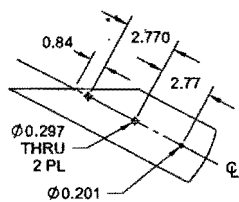
**NOTE:** Date & initial all entries

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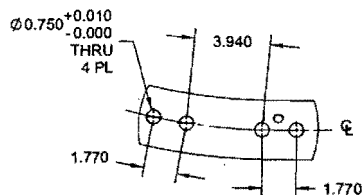


w/068739

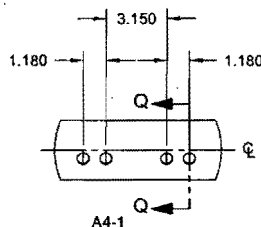
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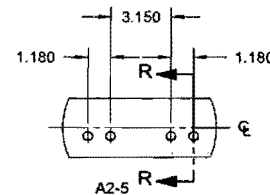
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SCALE 2X



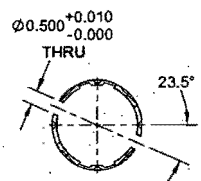
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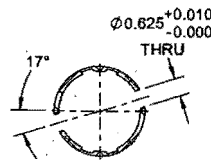
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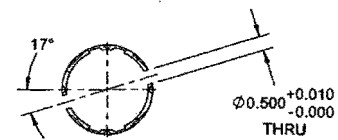
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**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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8 7 6 5 4 3 2 1

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

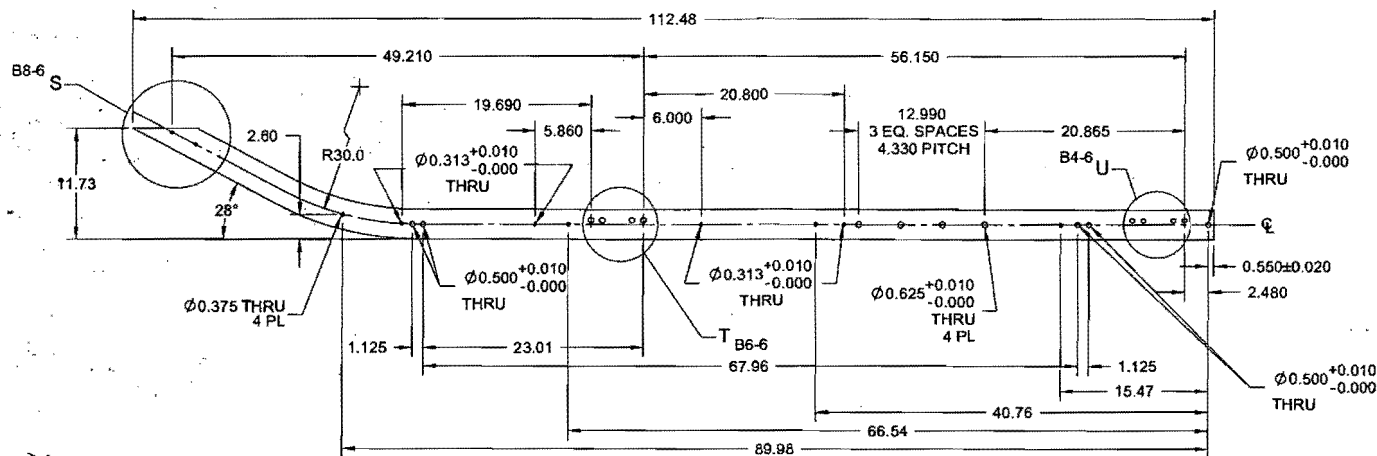
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

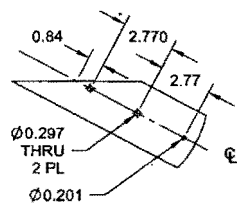
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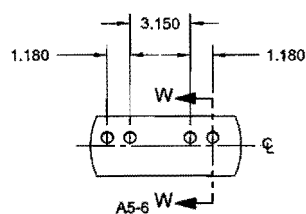
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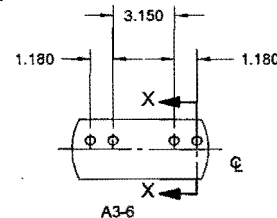
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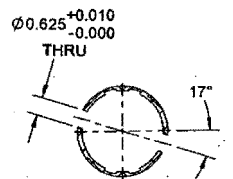
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SCALE 2X



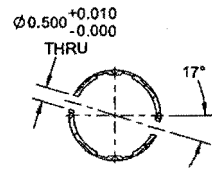
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SCALE 2X



**DETAIL U**  
SCALE 2X





**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

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DRAWN	SC	PORT HADLOCK, WA	
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MFG. APPR.		D4168	SHEET 6 OF 11
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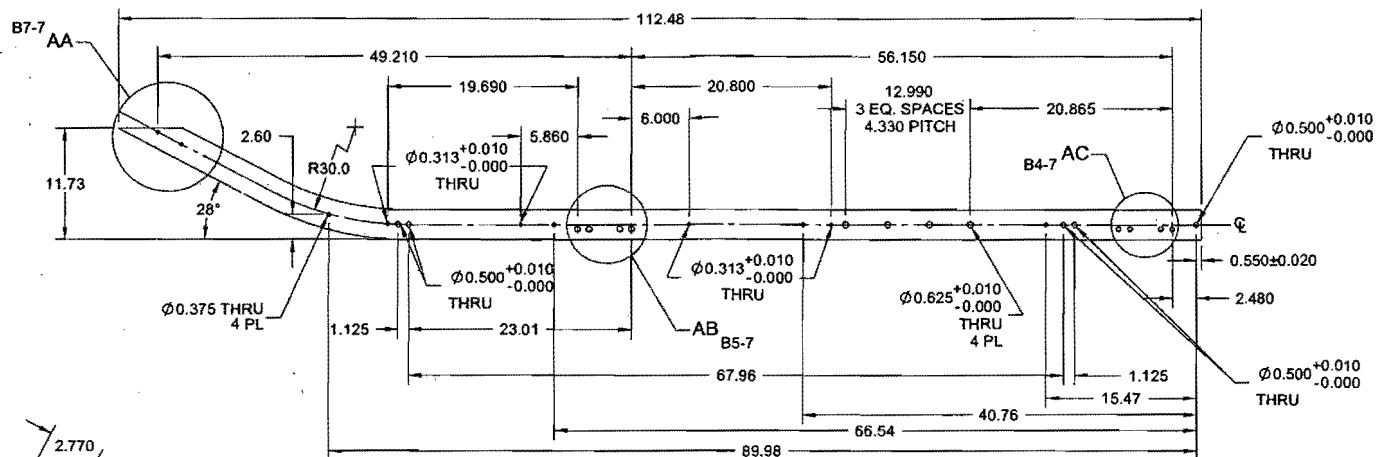
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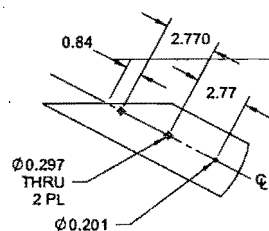
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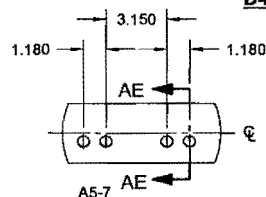
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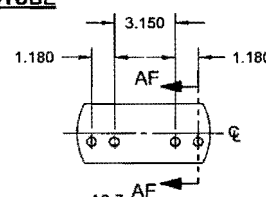
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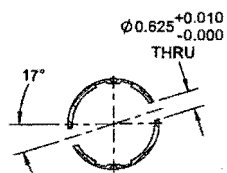
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SCALE 2X



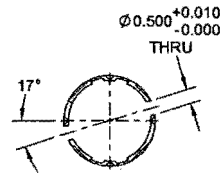
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SCALE 2X



**DETAIL AC**  
SCALE 2X



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

*w/lo 48739*

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MFG. APPR.		D4168	SHEET 7 OF 11
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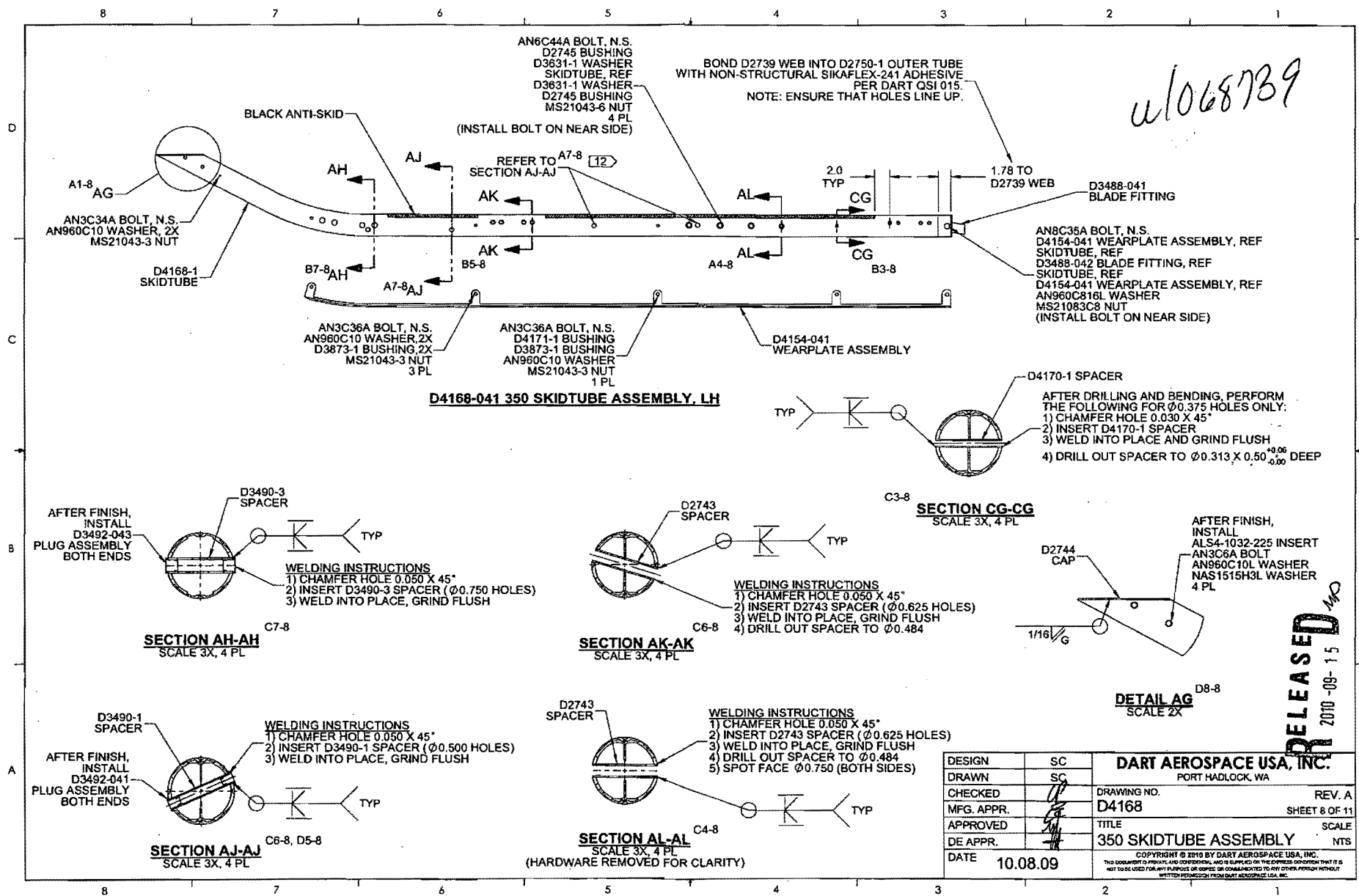
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

u/068739



DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4168	SHEET 8 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED  
2010-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

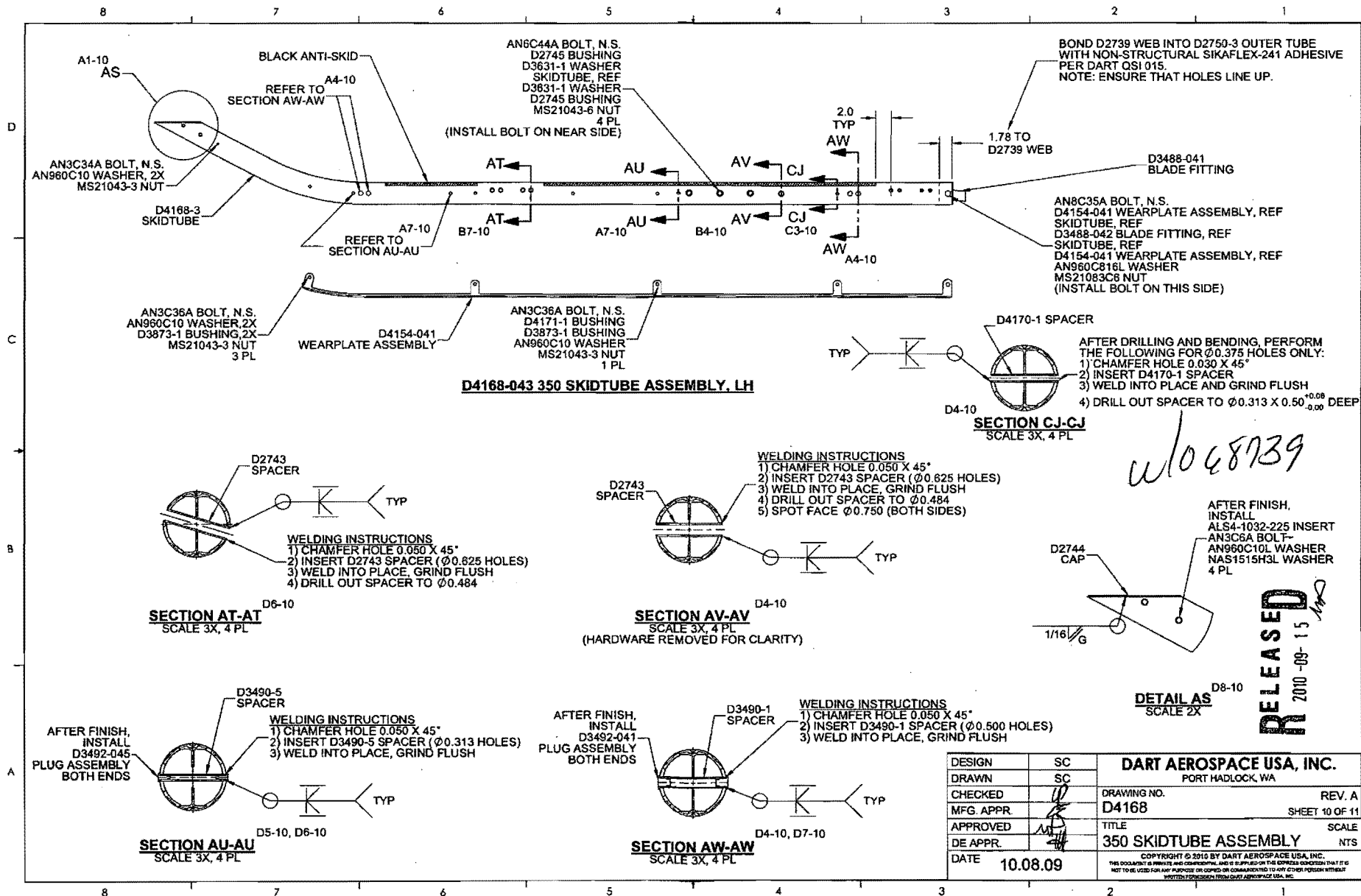
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





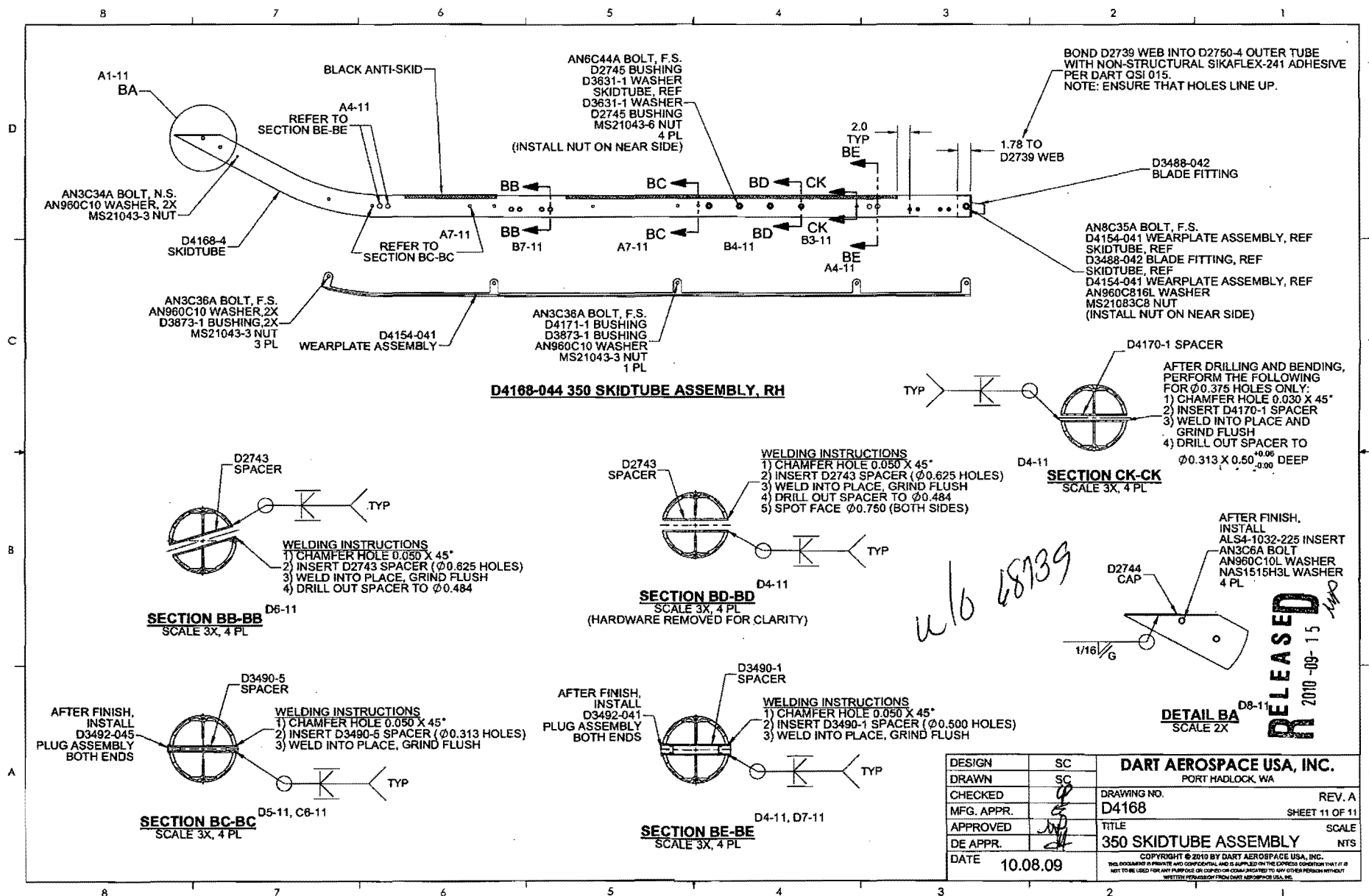
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 248

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 67178  
Part number: D350 636 015  
Description: 350  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat. Lipp Date of Test Coupon 11.04.05  
Welder Barclay Elliott Date of Test Coupon 11.04.05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld